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15 JANUARY 1949

SUPERSEDING  
Fed. Spec. TT-P-141a  
June 16, 1944

FEDERAL SPECIFICATION

P<sup>A</sup>INT, VARNISH, LACQUER, AND RELATED  
MATERIALS; METHODS OF INSPECTION,  
SAMPLING, AND TESTING

*This specification was approved by the Director, Bureau of Federal Supply,  
for the use of all departments and establishments of the Government.*

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RG 287  
351 3E2A/11/9 (Boxes T1152-T1171)

This Specification <sup>Part of Section IV, Part 5, of the Federal Standard Stock Catalog</sup>

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**Method 201.1**

15 JANUARY 1949

**PREPARATION OF STEEL PANELS****1. METAL AND GAGE**

1.1 Unless otherwise specified, all panels used shall be manufacturers' standard gage No. 20 (0.035 inch thick), S. A. E. 1020 cold-rolled steel. The surface finish shall be as specified. Test panels shall be cut 3 by 6 inches in size, if no other size is specifically directed.

**2. SOLVENT CLEANING**

2.1 Buff the panel lightly using steel wool and lacquer thinner. Remove all rust and corrosion spots by sanding with No. 240 sandpaper or equal emery cloth. Rinse panel with lacquer thinner using a soft bristle brush. Wipe dry with a clean rag. Degrease panel in perchloroethylene vapor for 5 minutes. When a perchloroethylene vapor cleaning machine is not available, cold dip can also be used. In this case, the solvent must be changed frequently.

**3. PHOSPHATE CLEANING**

3.1 Degrease first in accordance with 2.1 and then immerse panel in phosphate cleaner of the following composition at room temperature for 1 minute:

**FORMULA:**

3 milliliters syrupy phosphoric acid (85 percent).

1 milliliter Tergitol Penetrant No. 4 (Union Carbon & Carbide).

Water to make 1,000 milliliters.

Drain panel a few seconds in a vertical position and dry at 250° F. for 5 minutes.

**Caution:** Do not touch panels with bare fingers—use cotton gloves.

**NOTE 1.**—This general testing specification is written in such a manner as to permit tests to be run either on solvent-sanded steel or phosphoric-acid-cleaned steel. Unless solvent-cleaned steel is called for in the applicable specification, phosphoric-acid-treated panels shall be used. In the event solvent-cleaned steel panels are required, the cleaning procedure may be stopped upon the completion of the perchloroethylene degreasing. Where phosphoric-acid-treated panels are required, cleaning procedure shall be carried through the entire process given above. In either case, panels shall be used the day they are prepared and shall not be held over for subsequent days' work. When cleaned and awaiting application of paint, the panels shall be stored with sanded faces together and the whole stock protected by wrapping in clean cloth or paper.

*This Specification is a Part of Section IV, Part 5, of the Federal Standard Stock Catalog*

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